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(54) Title: STEPWISE ALKYLATION OF 5-SUBSTITUTED 1-(4-FLUOROPHENYL)-1,3-DIHYDROISOBENZOFURANS

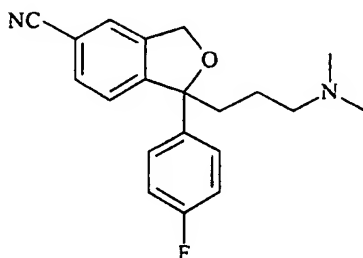
(57) Abstract: Methods for manufacture of citalopram through stepwise alkylation of 5-substituted 1-(4-fluorophenyl)-1,3-dihydroisobenzofurans are disclosed.

Stepwise alkylation of 5-substituted 1-(4-fluorophenyl)-1,3-dihydroisobenzofurans

The present invention relates to a method for the preparation of the well-known anti-depressant drug citalopram, 1-[3-(dimethylamino)propyl]-1-(4-fluorophenyl)-1,3-dihydro-5-isobenzofurancarbonitrile.

Background of the Invention

Citalopram is a well-known antidepressant drug that has now been on the market for some years and has the following structure:



It is a selective, centrally acting serotonin (5-hydroxytryptamine; 5-HT) reuptake inhibitor, accordingly having antidepressant activities. The antidepressant activity of the compound has been reported in several publications, eg. J. Hyttel *Prog. Neuro-Psychopharmacol. & Biol. Psychiat.* 1982, 6, 277-295 and A. Gravem *Acta Psychiatr. Scand.* 1987, 75, 478-486. The compound has further been disclosed to show effects in the treatment of dementia and cerebrovascular disorders, EP-A-474580.

Citalopram was first disclosed in DE 2,657,013, corresponding to US 4,136,193. This patent publication describes the preparation of citalopram by one method and outlines a further method, which may be used for preparing citalopram.

According to the process described, the corresponding 1-(4-fluorophenyl)-1,3-dihydro-5-isobenzofurancarbonitrile is reacted with 3-(N,N-dimethylamino)propyl-chloride in the presence of methylsulfinylmethide as condensing agent. The starting material was prepared from the corresponding 5-bromo derivative by reaction with cuprous cyanide.

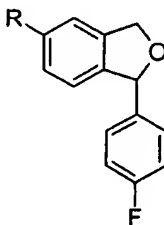
International patent application No. WO 98/019511 discloses a process for the manufacture of citalopram wherein a 4-(cyano, alkyloxycarbonyl or alkylaminocarbonyl)-2-hydroxy-methylphenyl-(4-fluorophenyl)methanol compound is subjected to ring closure. The resulting 5-(alkyloxycarbonyl or alkylaminocarbonyl)-1-(4-fluorophenyl)-1,3-dihydroisobenzofuran is converted to the corresponding 5-cyano derivative and the 5-cyano derivative is then alkylated with a (3-dimethylamino)propyl halogenide in order to obtain citalopram.

It has now, surprisingly, been found that citalopram may be manufactured by a novel favourable process where a 5-substituted 1-(4-fluorophenyl)-1,3-dihydroisobenzofuran is derivatised by stepwise addition of the 3-dimethylaminopropyl chain. Optionally, and dependent upon the nature of the substituent in the 5-position, said substituent is converted into a cyano-group at a suitable time in the reaction sequence.

Summary of the invention

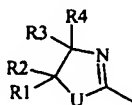
The invention comprises the following:

A method for preparation of citalopram, comprising subjecting the compound of formula I



I

wherein R represents CN, OH, O-triflate, halogen, NHR^5 wherein R^5 is selected from hydrogen and C_{1-6} alkylcarbonyl, CHO, CO_2R^6 , CONHR^7 wherein R^6 - R^7 are each independently selected from hydrogen and C_{1-6} alkyl, or R is a oxazoline or a thiazoline of the formula



wherein U is O or S;

$R^1 - R^2$ are each independently selected from hydrogen and C_{1-6} alkyl, or R^1 and R^2 together form a C_{2-5} alkylene chain thereby forming a spiro ring; R^3 is selected from hydrogen and C_{1-6} alkyl, R^4 is selected from hydrogen, C_{1-6} alkyl, a carboxy group or a precursor group therefore, or R^3 and R^4 together form a C_{2-5} alkylene chain thereby forming a spiro ring;

5 to a stepwise addition of reagents which eventually lead to the 3-(N,N-dimethylamino)-prop-1-yl substituent in citalopram. Optionally, if R is not CN, it is converted into a CN group at a suitable time in the reaction sequence.

The first aspect of the invention comprises addition of a C-1 chain:

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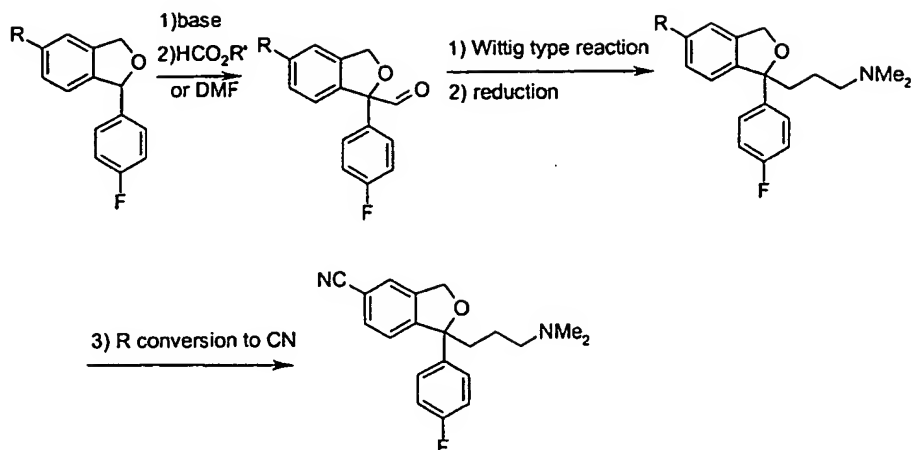
This reaction comprises the following subsequent steps, some of which may be performed together and the order of which may be changed in ways known to those skilled in the art:

- a) addition of a C-1 chain
- b) addition of a C-2-chain, which is optionally activated with regard to step c) or includes
- 15 simultaneous addition of NMe_2 or precursor thereof
- c) addition of NMe_2 or precursor thereof
- d) (optional) adjusting of oxidation level
- e) (optional) conversion of R to a 5-cyano-group
- f) (optional) conversion of NMe_2 -precursor to NMe_2 .

20

In one preferred embodiment of the above, the following steps are undertaken:

- a) addition of the C-1 chain
- b) addition of C-2 chain and of dimethylamino-substituent
- 25 c) adjustment of oxidation level (one-pot process with b))
- c) (optional) derivatising the substituent R to a 5-cyano-group

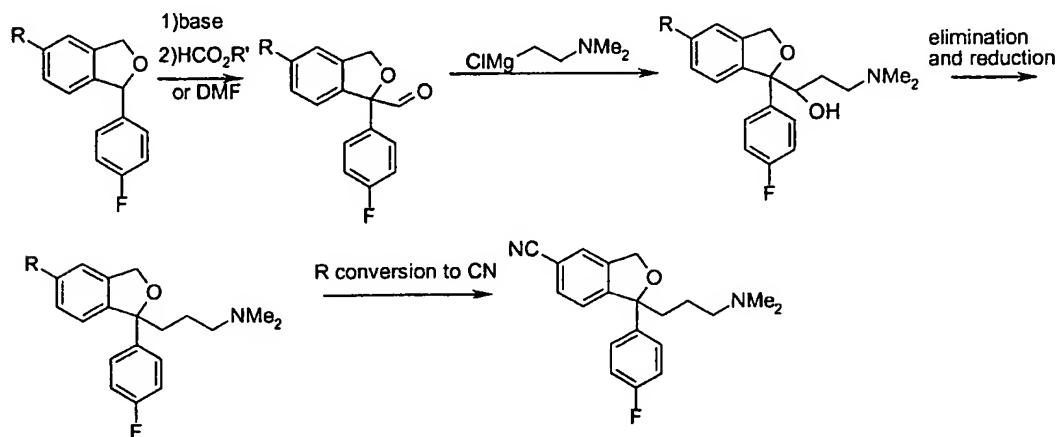


The Wittig reaction is known in the art and comprises an ylide derivative of suitable structure - in the present invention an ylide such as $\text{Ph}_3\text{P}=\text{CH}-\text{CH}_2\text{NMe}_2$. The product of this reaction contains a double bond which is reduced by methods known in the art.

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In another embodiment of the invention the following steps are performed:

- a) addition of the C-1
- b) Grignard reaction
- c) elimination and reduction
- 10 d) (optional) conversion of R to 5-cyano-group



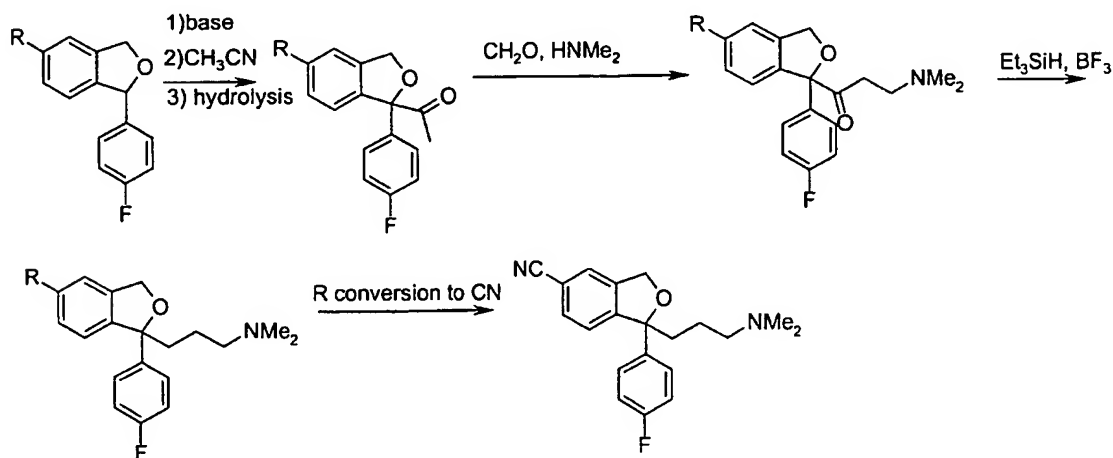
- In this aspect of the invention, addition of the C-1 group is performed by conventional methods, which are followed by a Grignard reaction. The product from the Grignard reaction is a secondary alcohol, which is subjected to elimination and subsequent reduction of the resulting double bond. Reduction of the double bond is performed by standard methods.
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Another aspect of the invention involves reacting the compound of formula I as above by addition of a C-2 chain. This aspect of the invention comprises the following steps some of which are performed together:

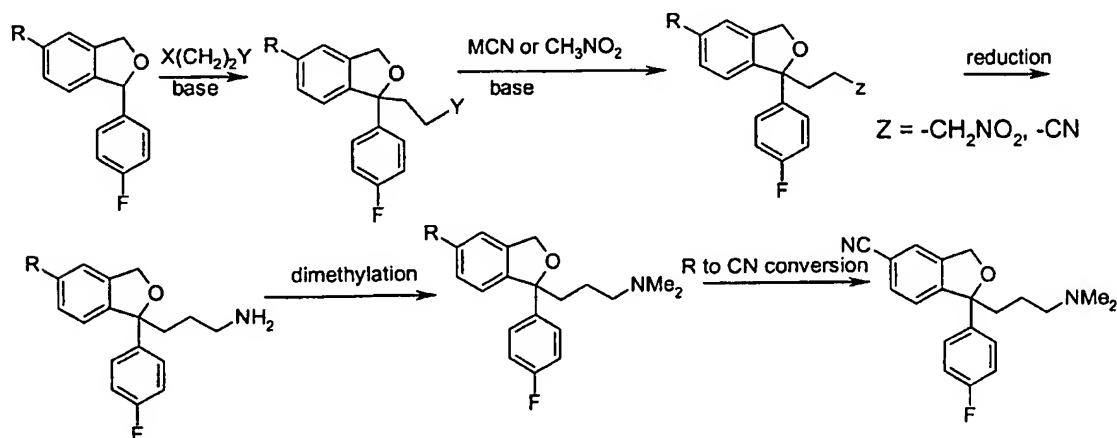
- a) addition of C-2-chain
- b) addition of C-1 which is optionally activated with regard to step c)
- c) addition of NMe_2 or a precursor for this group.
- d) optionally adjusting oxidation level;
- e) (optional) derivatising R to 5-cyano substituent

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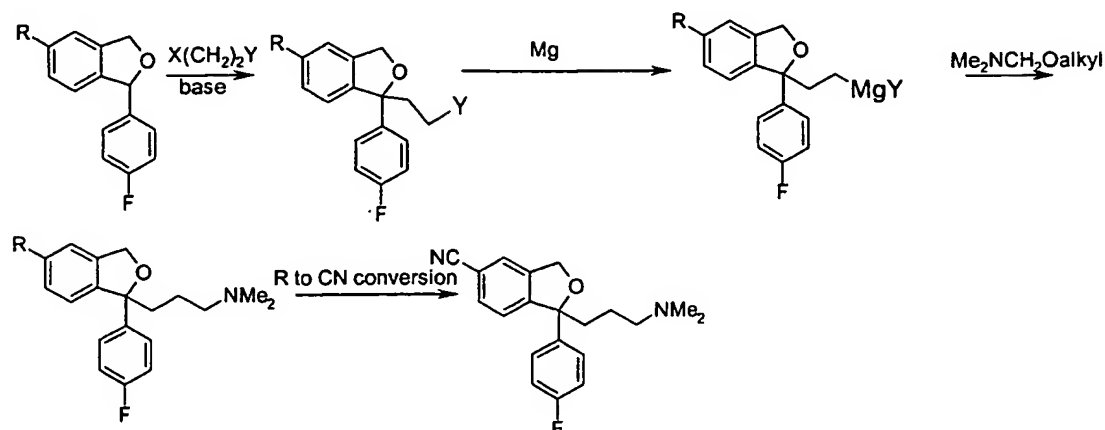
In one preferred embodiment of the invention, the following steps are performed:



- 15 In another preferred embodiment of the invention, the following steps are performed



In yet another embodiment of the invention, the following reactions are performed:



Reduction of the nitro group can be performed by methods known in the art. One preferred method is H_2 in the presence of Pd/C.

MCN represents metal cyanide such as NaCN, KCN, $Zn(CN)_2$ or CuCN.

Methylation of the amino group can be performed by *inter alia* CH_3I or by reductive amination of formaldehyde. Preferred reductive compounds are $NaBH_4$ or $NaCNBH_3$.

Detailed description of the invention:

The starting material of formula (I) may be prepared as described in US patent No. 4.136.193 or as described in WO 98/019511.

The first addition step where the compound of formula I is reacted with a C-1 or C-2 reagent, is suitably carried out by treatment of the compound of formula (I) with a base such as for example LDA (lithiumdiisopropylamine), LiHMDS, NaH, NaHMDS, and NaOMe in an aprotic organic solvent such as THF (tetrahydrofuran), DMF (dimethylformamide), NMP (N-methylpyrrolidone), ethers such as diethylether, or dioxalane, toluene, benzene, or alkanes and mixtures thereof followed by addition of the C-1 or C-2 reagent.

As used herein, a 'C-1 (C-2) reagent' is a reagent which in a chemical reaction is capable of adding a C-1 (C-2) fragment to a molecule.

Reductions can be performed by the methods known in the art.

The methods for converting the group R into a cyano substituent can be any of the following methods:

5

(i) R is O-triflates or halogen

When R is halogen or O-triflates of the formula $\text{CF}_3\text{-(CF}_2\text{)}_n\text{-SO}_2\text{-}$ wherein n is an integer in the range 0-8, incl., the conversion to a cyano group may be carried out by reaction with a
10 cyanide source, for example KCN, NaCN, CuCN, Zn(CN)_2 or $(\text{R}^8)_4\text{NCN}$ where $(\text{R}^8)_4$ indicates four groups which may be the same or different and are selected from hydrogen and straight chain or branched C_{1-6} alkyl, in the presence of a palladium catalyst and a catalytic amount of Cu^+ or Zn^{2+} , or with Zn(CN)_2 in the presence a palladium catalyst.

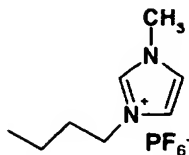
15 The cyanide source is used in a stoichiometric amount or in excess, preferably 1-2 equivalents are used pr. equivalent starting material. $(\text{R}^8)_4\text{N}^+$ may conveniently be $(\text{Bu})_4\text{N}^+$. The cyanide compound is preferably NaCN or KCN or Zn(CN)_2 .

The palladium catalyst may be any suitable Pd(0) or Pd(II) containing catalyst, such as
20 $\text{Pd(PPh}_3\text{)}_4$, $\text{Pd}_2(\text{dba})_3$, $\text{Pd(PPh)}_2\text{Cl}_2$, etc. The Pd catalyst is conveniently used in an amount of 1-10, preferably 2-6, most preferably about 4-5 mol%.

Catalytic amounts of Cu^+ and Zn^{2+} , respectively, means substoichiometric amounts such as 0.1 - 5, preferably 1 - 3 eq. % relative to reactants. Conveniently, about $\frac{1}{2}$ eq. is used per eq.
25 Pd. Any convenient source of Cu^+ and Zn^{++} may be used. Cu^+ is preferably used in the form of CuI and Zn^{2+} is conveniently used as the Zn(CN)_2 salt.

When R is Br or I, the conversion to a cyano group also may be carried out by reaction with Cu(CN) without catalyst. In a preferred embodiment, the reaction is performed at elevated
30 temperature.

In another aspect of the invention, the reaction is performed in an ionic liquid of the general formula $(\text{R}^9)_4\text{N}^+$, X^- , wherein R^9 are alkyl-groups or two of the R^9 groups together form an ring and X^- is the counterion. In one embodiment of the invention, $(\text{R}^9)_4\text{N}^+\text{X}^-$ represents



In another particular aspect, the reaction is conducted with apolar solvents such as benzene, xylene or mesitylene and under the influence of microwaves by using *i.e.* Synthewave 1000™ by Prolabo. In a particular aspect, the reaction is performed without added solvent.

5

The temperature ranges are dependent upon the reaction type. If no catalyst is present, preferred temperatures are in the range of 100-200 °C. However, when the reaction is conducted under the influence of microwaves, the temperature in the reaction mixture may raise to above 300 °C. More preferred temperature ranges are between 120-170 °C. The most preferred range is 130-150 °C.

10

If a catalyst is present, the preferred temperature range is between 0 and 100 °C. More preferred are temperature ranges of 40-90 °C. Most preferred temperature ranges are between 60-90 °C.

15

Other reaction conditions, solvents, etc. are conventional conditions for such reactions and may easily be determined by a person skilled in the art.

20

When R is Cl or Br, the conversion to a cyano group may also be carried out by reaction with a cyanide source, for example KCN, NaCN, CuCN, Zn(CN)₂ or (R⁸)₄N)CN where (R⁸)₄ indicates four groups which may be the same or different and are selected from hydrogen and straight chain or branched C₁₋₆ alkyl, in the presence of a nickel catalyst.

25

The nickel catalyst may be any suitable Ni(0) or Ni(II) containing complex which acts as a catalyst, such as Ni(PPh₃)₃, (η-aryl)-Ni(PPh₃)₂Cl, etc. The nickel catalysts and their preparation are described in WO 96/11906, EP-A-613720 or EP-A-384392.

In one embodiment of the invention, the reaction is carried out in the presence of a catalytic amount of Cu⁺ or Zn²⁺.

30

In a particularly preferred embodiment, a nickel(0) complex is prepared *in situ* before the cyanation reaction by reduction of a nickel(II) precursor such as NiCl_2 or NiBr_2 by a metal, such as zinc, magnesium or mangan in the presence of excess of complex ligands, preferably triphenylphosphin.

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The Ni-catalyst is conveniently used in an amount of 0.5-10, preferably 2-6, most preferably about 4-5 mol%.

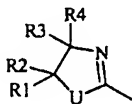
Catalytic amounts of Cu^+ and Zn^{2+} , respectively, means substoichiometric amounts such as 10 0.1 - 5, preferably 1 - 3 eq. %. Any convenient source of Cu^+ and Zn^{2+} may be used. Cu^+ is preferably used in the form of CuI and Zn^{2+} is conveniently used as the $\text{Zn}(\text{CN})_2$ salt or formed *in situ* by reduction of a Nickel (II) compounds using zinc.

The Ni catalysts are *i.e.* Ni (0), Pd(0) or Pd(II) catalysts as described by Sakakibara et. al. in 15 *Bull. Chem. Soc. Jpn.* **1988**, 61, 1985-1990. Preferred catalysts are $\text{Ni}(\text{PPh}_3)_3$ or $\text{Pd}(\text{PPh}_3)_4$, or $\text{Pd}(\text{PPh})_2\text{Cl}_2$.

The reactions may be performed in any convenient solvent as described in Sakakibara et. al. in *Bull. Chem. Soc. Jpn.* **1988**, 61, 1985-1990,. Preferred solvents are acetonitril, 20 ethylacetat, THF, DMF or NMP.

R is a oxazoline or thiazoline.

When R is an oxazoline or a thiazoline of the formula



25

wherein U is O or S;

$\text{R}^1 - \text{R}^4$ are each independently selected from hydrogen and C_{1-6} alkyl, or R^3 and R^4 together form a C_{2-5} alkylene chain thereby forming a spiro ring; R^1 is selected from hydrogen and C_{1-6} alkyl, R^2 is selected from hydrogen, C_{1-6} alkyl, a carboxy group or a precursor group 30 therefore, or R^1 and R^2 together form a C_{2-5} alkylene chain thereby forming a spiro ring; the conversion to a cyano group may be carried out by dehydration or alternatively where U is

S, thermally cleavage of the thiazoline ring or treatment with a radical initiator, such as peroxide or with light.

The dehydration agent may be any suitable dehydration agent conventionally used in the art, such as phosphoroxyltrichloride, thionylchloride, phosphoropentachloride, PPA (polyphosphoric acid) and P_4O_{10} . The reaction may be carried out in the presence of an organic base, such as pyridine.

Alternatively, the dehydration agent may be a Vilsmeier reagent, i.e. a compound which is formed by reaction of a chlorinating agent, preferably an acid chloride, e.g. phosgene, oxalyl chloride, thionyl chloride, phosphoroxylchloride, phosphoropentachloride, trichloromethyl chloroformate, also briefly referred to as "diphosgene", or bis(trichloromethyl) carbonate, also briefly referred to as "triphosgene", with a tertiary amide such as N,N-dimethylformamide or a N,N-dialkylalkanamide, e.g. N,N-dimethylacetamide. A classic Vilsmeier reagent is the chloromethylenedimethyliminium chloride. The Vilsmeier reagent is preferably prepared *in situ* by adding the chlorinating agent to a mixture containing the starting oxazoline or thiazoline derivative and the tertiary amide.

When U is S and the conversion of the thiazoline group into the cyano group is made by thermal transformation, the thermal decomposition of the thiazoline is preferably carried out in an anhydrous organic solvent, more preferably an aprotic polar solvent, such as N,N-dimethylformamide, N,N-dimethylacetamide, dimethylsulfoxide or acetonitrile. The temperature at which the thermal decomposition transforms the 2-thiazolyl group to a cyano group is between 60 °C and 140 °C. The thermal decomposition may conveniently be carried out by reflux in a suitable solvent, preferably acetonitrile. The thermal cleavage may conveniently be carried out in the presence of oxygen or an oxidation agent. A thiazoline group where U is S and R^3 or R^4 is a carboxy group or a precursor for a carboxy group can also be converted to citalopram by treatment with a radical initiator such as light or peroxides.

R is CHO, CO_2R^6 or $CONHR^7$

When R is CHO, the conversion to a cyano group may be carried out by conversion of the formyl group to an oxime or similar group by reaction with a reagent $R^{10}-V-NH_2$ wherein R^{10} is hydrogen, lower alkyl, aryl or heteroaryl and V is O, N or S, followed by conversion to a cyano group by a common dehydrating agent, for example thionylchloride, acetic anhydride/pyridine, pyridine/HCl or phosphor pentachloride. Preferred reagents $R^{10}-V-NH_2$ are hydroxylamin and compounds wherein R^{10} is alkyl or aryl and V is N or O.

When R is $-COOR^6$, the conversion to a cyano group may be carried out via the corresponding acid chloride, or ester and amide.

10

The acid chloride is conveniently obtained by treatment of the acid with $POCl_3$, PCl_5 or $SOCl_2$ neat or in a suitable solvent, such as toluene or toluene comprising a catalytic amount of N,N-dimethylformamide. The ester is obtained by treatment of the acid with an alcohol R^6-OH , wherein R^6 is as defined above, in the presence of an acid, preferably a mineral acid or a Lewis acid, such as HCl, H_2SO_4 , $POCl_3$, PCl_5 or $SOCl_2$. Alternatively, the ester may be obtained from the acid chloride by reaction with an alcohol. The ester or the acid chloride is then converted to an amide of by amidation with ammonia or an C_{1-6} alkylamine, preferably t-butyl amine.

The conversion to amide may also be obtained by reaction of the ester with ammonia or an alkylamine under pressure and heating.

The amide group is then converted to a cyano group by dehydration. The dehydrating agent may be any suitable dehydrating agent, and the optimal agent may easily be determined by a person skilled in the art. Examples of suitable dehydrating agents are $SOCl_2$, $POCl_3$ and PCl_5 , preferably $SOCl_2$.

In a particularly preferred embodiment, the carboxylic acid is reacted with an alcohol, R^6OH , preferably ethanol, in the presence of $POCl_3$, in order to obtain the corresponding ester, which is then reacted with ammonia thereby giving the corresponding amide, which in turn is reacted with $SOCl_2$ in toluene comprising a catalytic amount of N,N-dimethylformamide.

Alternatively, a compound where R is $-\text{COOH}$ may be reacted with chlorosulfonyl isocyanate in order to form the nitrile, or treated with a dehydrating agent and a sulfonamide as described in PCT/DK/0000032.

5 R is NHR^5 .

When R is $-\text{NHR}^5$, where R^5 is hydrogen, the conversion into cyano is preferably performed by diazotation and followed by reaction with CN^- . Most preferably NaNO_2 and CuCN and/or NaCN are used. When R^5 is C_{1-6} alkylcarbonyl, it is initially subjected to hydrolysis
10 thereby obtaining the corresponding compound wherein R^5 is H which is then converted as described above. The hydrolysis may be performed either in acidic or basic environment.

Citalopram may be used as the free base or as a pharmaceutically acceptable acid addition salt thereof. As acid addition salts, such salts formed with organic or inorganic acids may
15 be used. Examples of such organic salts are those with maleic, fumaric, benzoic, ascorbic, succinic, oxalic, bismethylenesalicylic, methanesulfonic, ethanedisulfonic, acetic, propionic, tartaric, salicylic, citric, gluconic, lactic, malic, mandelic, cinnamic, citraconic, aspartic, stearic, palmitic, itaconic, glycolic, p-aminobenzoic, glutamic, benzene sulfonic and theophylline acetic acids, as well as the 8-halotheophyllines, for example 8-
20 bromotheophylline. Exemplary of such inorganic salts are those with hydrochloric, hydrobromic, sulfuric, sulfamic, phosphoric and nitric acids.

The acid addition salts of the compounds may be prepared by methods known in the art. The base is reacted with either the calculated amount of acid in a water miscible solvent, such as
25 acetone or ethanol, with subsequent isolation of the salt by concentration and cooling, or with an excess of the acid in a water immiscible solvent, such as ethylether, ethylacetate or dichloromethane, with the salt separating spontaneously.

The pharmaceutical compositions of the invention may be administered in any suitable way
30 and in any suitable form, for example orally in the form of tablets, capsules, powders or syrups, or parenterally in the form of usual sterile solutions for injection.

The pharmaceutical formulations of the invention may be prepared by conventional methods in the art. For example, tablets may be prepared by mixing the active ingredient with ordinary adjuvants and/or diluents and subsequently compressing the mixture in a conventional tableting machine. Examples of adjuvants or diluents comprise: Corn starch, potato starch, talcum, magnesium stearate, gelatine, lactose, gums, and the like. Any other adjuvant or additive colourings, aroma, preservatives etc. may be used provided that they are compatible with the active ingredients.

Solutions for injections may be prepared by solving the active ingredient and possible additives in a part of the solvent for injection, preferably sterile water, adjusting the solution to the desired volume, sterilising the solution and filling it in suitable ampoules or vials. Any suitable additive conventionally used in the art may be added, such as tonicity agents, preservatives, antioxidants, etc.

Throughout the specification and claims, the term alkyl refers to a branched or unbranched alkyl group having from one to six carbon atoms inclusive, such as methyl, ethyl, 1-propyl, 2-propyl, 1-butyl, 2-butyl, 2-methyl-2-propyl, 2,2-dimethyl-1-ethyl and 2-methyl-1-propyl.

Similarly, alkenyl and alkynyl, respectively, designate such groups having from two to six carbon atoms, including one double bond and triple bond respectively, such as ethenyl, propenyl, butenyl, ethynyl, propynyl, and butynyl.

The term aryl refers to a mono- or bicyclic carbocyclic aromatic group, such as phenyl and naphthyl, in particular phenyl.

The term aralkyl refers to aryl-alkyl, wherein aryl and alkyl is as defined above.

Halogen means chloro, bromo or iodo.

Example

Synthesis of Citalopram via 1-(4-fluorophenyl)-1-formyl-1,3-dihydro-5-isobenzofurancarbonitrile:

1-(4-Fluorophenyl)-1-formyl-1,3-dihydro-5-isobenzofurancarbonitrile. A solution of 1-(4-fluorophenyl)-1,3-dihydro-5-isobenzofurancarbonitrile (2.4 g, 10 mmol) in THF (15 mL) was added to a solution of LDA (11 mmol) in THF (25 mL) at -78°C under an atmosphere of nitrogen. The mixture was allowed to warm to -40°C during 45 min. Freshly distilled methyl formate (0.75 mL, 12 mmol) was added at this temperature, and stirring was continued for 1 h while warming to 0°C . Then the mixture was poured into ice/saturated ammonium chloride solution, and extracted with Et₂O (3 \times 100 mL). The organic extracts were washed with brine, dried and evaporated. Silica gel chromatography (heptane, EtOAc 4:1) of the residue gave the product (1.3 g, 50%). ¹H NMR (CDCl₃) δ 5.35 (2H, s); 7.10 (2H, t, J = 9.0 Hz); 7.50 (1H, dd, J = 5.2 and 9.0 Hz); 7.57 (1H, s); 7.60 (1H, d, J = 8.0 Hz); 7.70 (1H, d, J = 8.0 Hz).

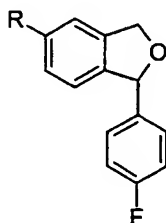
1-[3-(Ethoxycarbonyl)ethyl]-1-(4-fluorophenyl)-1,3-dihydro-5-isobenzofurancarbonitrile. Triethyl phosphonoacetate (5.1 mL, 22.8 mmol) was added to a solution of LDA (22.8 mmol) in THF (100 mL) at -30°C under an atmosphere of nitrogen. The mixture was stirred at this temperature for 1 h, then a solution of 1-(4-fluorophenyl)-1-formyl-1,3-dihydro-5-isobenzofurancarbonitrile (5.8 g, 21.7 mmol) in THF (50 mL) was added. The mixture was allowed to warm to room temperature during 2.5 h, then poured into ice/H₂O. The pH was adjusted to about 5 by addition of acetic acid and the aqueous phase was extracted with Et₂O, dried and evaporated. The crude product (8.0 g) was hydrogenated in ethanol (150 mL) using Pt/C (1.7 g, 5%) as catalyst. After 16 h, the mixture was filtered through Celite and evaporated. Silica gel chromatography (heptane, EtOAc 5:1) afforded the product as an oil (4.2 g, 57%). ¹H NMR (CDCl₃) δ 1.20 (3H, t, J = 7.0 Hz); 2.25 (2H, m); 2.50 (2H, m); 4.05 (2H, q, J = 7.0 Hz); 5.15 (1H, d, J = 12.7 Hz); 5.19 (1H, d, J = 12.7 Hz); 7.02 (2H, t, J = 9.0 Hz); 7.40 (3H, m); 7.50 (1H, s); 7.60 (1H, d, J = 8.0 Hz).

1-[3-(N,N-Dimethylamido)ethyl]-1-(4-fluorophenyl)-1,3-dihydro-5-isobenzofurancarbonitrile. Methyl chloroaluminum dimethylamide (30 mL, 20 mmol, prepared from dimethylammonium chloride and trimethyl aluminum in toluene) was added to a solution of 1-[3-(ethoxycarbonyl)ethyl]-1-(4-fluorophenyl)-1,3-dihydro-5-isobenzofurancarbonitrile (2.6 g, 7.7 mmol) in toluene (50 mL). The resulting mixture was stirred at 50°C for 19 h, cooled, poured into ice /H₂O and extracted with Et₂O (3 \times 200 mL). The organic extracts were dried and evaporated to give the product as an oil (2.6 g, 100%). ¹H NMR (CDCl₃) δ

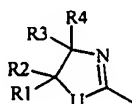
2.26 (2H, t, $J = 8.0$ Hz); 2.45 (1H, ddd, $J = 1.8$ and 9.9 and 16.0 Hz); 2.59 (1H, ddd, $J = 8.0$ and 14.6 and 16.0 Hz); 2.86 (1H, s); 2.88 (1H, s); 5.15 (1H, d, $J = 13.0$ Hz);); 5.20 (1H, d, $J = 13.0$ Hz); 7.02 (2H, t, $J = 8.9$ Hz); 7.41 (1H, d, $J = 8.0$ Hz); 7.44 (2H, dd, $J = 5.2$ and 8.9 Hz); 7.50 (1H, s); 7.58 (1H, d, $J = 8.0$ Hz).

Claims

1. A method for the preparation of citalopram comprising reacting a compound of formula (I)



wherein R represents CN, OH, O-triflate, halogen, NHR^5 wherein R^5 is hydrogen or C_{1-6} alkylcarbonyl, CHO, CO_2R^6 , CONHR^7 wherein R^6 and R^7 each independently are hydrogen or C_{1-6} alkyl or R is a oxazoline or a thiazoline of the formula



wherein U is O or S;

R^1 - R^2 are each independently selected from hydrogen and C_{1-6} alkyl, or R^1 and R^2 together form a C_{2-5} alkylene chain thereby forming a spiro ring; R^3 is selected from hydrogen and C_{1-6} alkyl, R^4 is selected from hydrogen, C_{1-6} alkyl, a carboxy group or a precursor group therefore, or R^3 and R^4 together form a C_{2-5} alkylene chain thereby forming a spiro ring;

with reagents thereby obtaining a stepwise addition of the 3-(N, N-dimethylamino)propyl substituent.

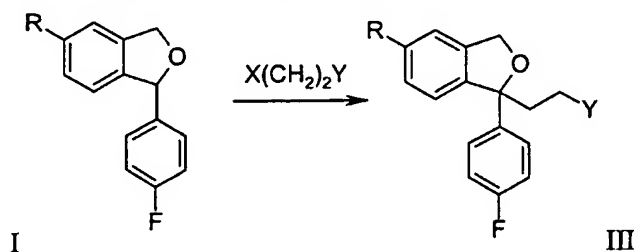
2. The method of claim 1 wherein a one-carbon group is added initially.

3. The method of claim 1 wherein a two-carbon chain is added initially.

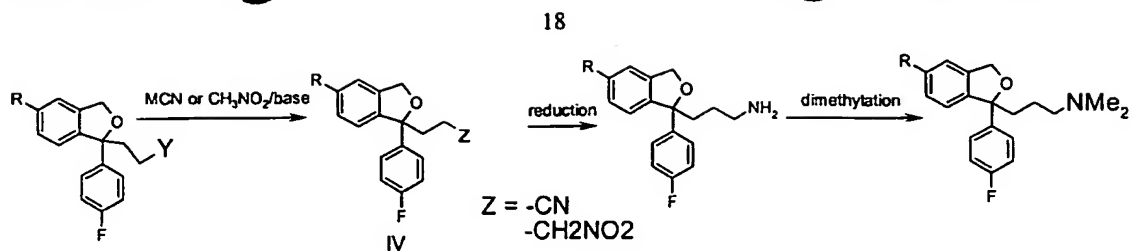
4. The method of any of claims 1 and 2 wherein the carbon is added by reacting a compound of formula (I) with DMF or $\text{HCO}_2\text{R}'$ in the presence of a base.

5. The method of any of claims 1 and 2 wherein the carbon is added by reacting a compound of formula (I) with CH_2O in the presence of a base.

6. The method of any of claims 1 and 2 wherein the carbon is added by reacting a compound of formula (I) with CO_2 in the presence of a base;
7. The method of claim 6 wherein the carboxyl-derivative is reduced to the hydroxymethyl derivative.
8. The method of any of claims 1, 2, 6 and 7 wherein the subsequent reactions comprise activation followed by alkylation via cuprate derivatives.
9. The method of any of claims 1 and 3 wherein the two carbon chain is added by reaction of the compound of formula (I) with CH_3CN in the presence of a base.
10. The method of any of claims 1 and 3 wherein the two carbon chain is added by reaction of the compound of formula (I) with acetylene.
11. The method of any of claims 9 or 10, wherein the subsequent reactions comprise addition of CH_2O and HNMe_2 .
12. The method according to claim 3 wherein the reaction is performed by subjection a compound of formula I to base and $\text{X}(\text{CH}_2)_2\text{Y}$ wherein X and Y are leaving groups.



13. The method according to claim 12 wherein Y is halogen.
14. The method according to any of claims 1, 3, 12, 13 wherein the compound III is reacted with MCN or CH_3NO_2 in the presence of base to form a compound of formula IV which is subsequently reduced and then dimethylated by CH_3I or by reductive amination of CH_2O



15. The method according to claim 14 wherein the reductive reagent is NaBH_4 or
- 5 NaCNBH_3 .
16. The method according to claim 12 wherein Mg is added to a compound of formula III followed by addition of $\text{Me}_2\text{NCH}_2\text{O-alkyl}$.
- 10 17. The method according to any of claims 1-16 wherein the group R is not a CN group and is converted into a CN group at any suitable stage of the reactions.
18. Citalopram prepared according to the method of claims 1-17.

INTERNATIONAL SEARCH REPORT

International application No.

PCT/DK 01/00159

A. CLASSIFICATION OF SUBJECT MATTER

IPC7: C07D 307/87

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC7: C07D

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

SE,DK,FI,NO classes as above

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

C. DOCUMENTS CONSIDERED TO BE RELEVANT

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X	US 4136193 A (KLAUS P. BOGESO ET AL), 23 January 1979 (23.01.79) --	1-18
X	WO 9819511 A2 (H. LUNDBECK A/S), 14 May 1998 (14.05.98) --	1-18
X	Eur. J. Med. Chem. - Chimica Therapeutica, Volume 12, No 3, 1977, Allan J. Bigler et al, "Quantitative structure-activity relationships in a series of selective 5-HT uptake inhibitors" page 289 - page 295 --	1-18

☒ Further documents are listed in the continuation of Box C.☒ See patent family annex.

* Special categories of cited documents:

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"O" document referring to an oral disclosure, use, exhibition or other means

"P" document published prior to the international filing date but later than the priority date claimed

"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

"X" document of particular relevance: the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

"Y" document of particular relevance: the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art

"&" document member of the same patent family

Date of the actual completion of the international search

Date of mailing of the international search report

12 June 2001

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INTERNATIONAL SEARCH REPORT

International application No.

PCT/DK 01/00159

C (Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
E,X	EP 1095926 A2 (SUMIKA FINE CHEMICALS CO., LTD.), 2 May 2001 (02.05.01) -- -----	1-18

INTERNATIONAL SEARCH REPORT
Information on patent family members

28/05/01

International application No.

PCT/DK 01/00159

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